

Date: Wednesday, 3/8/2006 10:38:50 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLANGE PLATE
Job Number : 26130	
Estimate Number : 12235	
P.O. Number : N/A	Part Number : D34771
This Issue : 3/8/2006 S.O. No. : N/A	Drawing Number : D3477 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 3/31/2006 Qty: 10 Um: Each
Checked & Approved By : [Signature] 06.03.08	
Comment : Est Rev:A New Issue 06-02-07 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: Issue P/O: 00000768 [Signature] 06/23/09
E-mail or Ship DXF file to vendor
Laser cut flat pattern as per Dwg D3477
Possible supplier: Ind. Laser
Material release note is required.

2.0	D34771F	Flange flat pattern
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
FLANGE PLATE

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure material certification is attached

06.03.22 (10)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

06.03.22 (16)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

2-Form as per Dwg D3477 using Dt8858 A,B&C

06.03.27 (17) [Signature]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		On Lab for template	VB	06.03.21	1	VB 06.03.21	VB 06.03.21
		ADD inspection level 21	EE	06.04.23			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/03/20
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:38:50 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLANGE PLATE

Job Number: 26130

Part Number: D34771

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/03/30

8

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

06-03-29

Job Completion



Inspection Level 21 06/03/30

U 06/03/30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

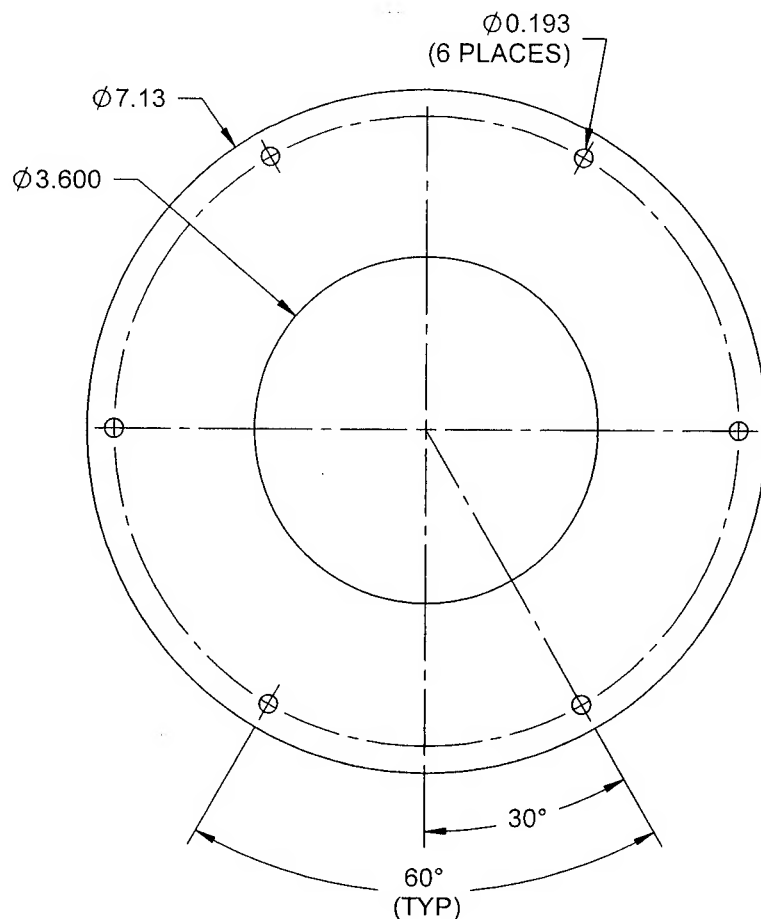
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

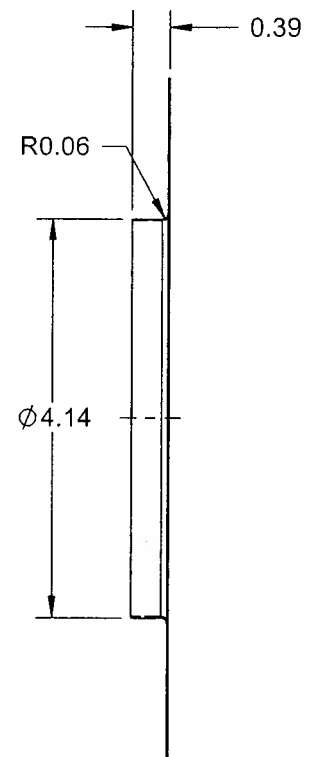
NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3477	REV. A SHEET 2 OF 4
DATE 05.12.09		TITLE BLOWER INLET ADAPTER	SCALE 1:2



D3477-1F FLANGE
FLAT PATTERN



D3477-1
FLANGE

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

3/13/06
604-946-4153
07/13/06
JETE

AK Steel Corporation Metallurgical Test Report Coshington Works Coshington, OH 43812		Lead No. 71672 BSN No. 71671	Fig. 1	
INTEGRIS METALS PO BOX 340 MARIETTA, OH 45750		INTRINSIC METALS 306 B STREET MARIETTA, OH 45750	MILL ORDER NO. 77185-0191 PROCESSOR ORDER NO. 427135-01 BUYER ORDER NO. 427135-01	
EXHAUST UNITS - PRODUCT - METAL UNITS 427135-01		EXHAUST UNITS - PRODUCT - METAL UNITS 427135-01	427135-01	
SKID ID FECH HEAT PARENT COIL ID NET WEIGHT		SKID13A3 SKID13A4 SKID13A5 SKID13A6 SKID13A7 SKID13A8 SKID13A9 SKID13B0 SKID13B1 SKID13B2 SKID13B3 SKID13B4 SKID13B5 SKID13B6 SKID13B7 SKID13B8 SKID13B9 SKID13C0 SKID13C1 SKID13C2 SKID13C3 SKID13C4 SKID13C5 SKID13C6 SKID13C7 SKID13C8 SKID13C9 SKID13D0 SKID13D1 SKID13D2 SKID13D3 SKID13D4 SKID13D5 SKID13D6 SKID13D7 SKID13D8 SKID13D9 SKID13E0 SKID13E1 SKID13E2 SKID13E3 SKID13E4 SKID13E5 SKID13E6 SKID13E7 SKID13E8 SKID13E9 SKID13F0 SKID13F1 SKID13F2 SKID13F3 SKID13F4 SKID13F5 SKID13F6 SKID13F7 SKID13F8 SKID13F9 SKID13G0 SKID13G1 SKID13G2 SKID13G3 SKID13G4 SKID13G5 SKID13G6 SKID13G7 SKID13G8 SKID13G9 SKID13H0 SKID13H1 SKID13H2 SKID13H3 SKID13H4 SKID13H5 SKID13H6 SKID13H7 SKID13H8 SKID13H9 SKID13I0 SKID13I1 SKID13I2 SKID13I3 SKID13I4 SKID13I5 SKID13I6 SKID13I7 SKID13I8 SKID13I9 SKID13J0 SKID13J1 SKID13J2 SKID13J3 SKID13J4 SKID13J5 SKID13J6 SKID13J7 SKID13J8 SKID13J9 SKID13K0 SKID13K1 SKID13K2 SKID13K3 SKID13K4 SKID13K5 SKID13K6 SKID13K7 SKID13K8 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SHIPPING DATE: 09/14/2005 REMARKS: NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS, RADIUM, ALPHA SOURCE, AND LOW MELTING ALLOYS OR ELEMENTS CAPABLE OF FORMING LOW MELTING ALLOYS WERE MADE THROUGHOUT THE PROCESSING OF THIS MATERIAL.		PRODUCT DESCRIPTION CR SET TYPE 304 SEAMLESS 126 PLAIN SLIT PIPE * AND 304 * ALL TUBE ENDS HAVE BEEN END FINISHED TO OR NOTED OTHERWISE * A SIZE SA-240 SECTION II PART B (2001 ED. 2002 ADDENDA) EX PARA 3.1.1.3 BLOCK WILL BE DETERMINED BY PART B 3 * EX-10204 3.1.3 H & B EX PARA 28.1.1.3 COIL WILL BE TAGGED ON ORIGIN ONLY * ASME B 866-03 * EX-011 NEW 0, * EX-011 0 * BUYER PART# 72261497 * SIZE SA-240-04 EX PARA 3.1.1.3 BLOCK WILL BE DETERMINED BY PART B 3 * ASME B 450-01 EX PARA 19.1.1.1 BLOCK WILL BE DETERMINED BY ASME		
CHEMICAL ANALYSIS L-Label Analysis of Heat P-Product Analysis of Parent Coil		CHEMICAL ANALYSIS L-Label Analysis of Heat P-Product Analysis of Parent Coil		
ID C MN P S SI CR NI MO N CU CO		ID C MN P S SI CR NI MO N CU CO		
L 7226131 .049 2.39 .027 .001 .35 1.8.18 8.05 .35 .04 .30 .12		L 7226131 .049 2.39 .027 .001 .35 1.8.18 8.05 .35 .04 .30 .12		

MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 IMPERIAL ROAD NORTH

Page : 1
Heat/Lot : 86K9
TIN : B42748

Sold To: INTEGRIS METALS, LTD.
7910 49TH STREET SE
CALGARY, AB T2C2Y3

Ship To: ***CUSTOMER PICKUP***
4375 14TH STREET NORTHEAST
CALGARY
ABT3E7A9

Vendor Information

Cust PO #: 406824

Cust PO DT: 11/03/05

Specifications

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/04a 480/04a, 666/03, ASMESA240/04-A05, 480/04-A05, SA666/04
Q08766D-A X 1/8 PRM, AMS5513H X MRK&FIN, MILS059D, AMD3, X CRWN MEAS
CORROSION: ASTM A262/02aB; 180Bend-OK
Buyer Part: 4288441
304 2B .1305 IN 48 IN 96 IN
Country of Origin: UNITED STATES

Mechanical Tests

		UOM	L	O	UOM	L	O
Yield Strength - 0.2% Offset	40	KSI	F	TRANSV			
Tensile Strength (UTS)	93.3	KSI	F	TRANSV			
Rockwell B	85		F	TRANSV			
Pct Uniform Elong 2 In/50mm	57.01	PCT	F	TRANSV			
Rockwell A	85		T	TRANSV			

Chemical Composition

C Carbon-Pct	.059	CR Chromium-Pct	18.360
CU Copper-Pct	.342	MN Manganese-Pct	1.643
MO Molybdenum-Pct	.285	N Nitrogen-Pct	.037
NI Nickel-Pct	8.150	P Phosphorus-Pct	.029
SI Silicon-Pct	.289		

Comments

MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 IMPERIAL ROAD NORTH

Page : 2
Heat/Lot : 86K8
TIN : B42748

Material free from mercury contamination. No weld repairs.
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 QOS763F Cond A
This document certifies the material has been tested in
accordance with applicable specifications described herein
and has met those requirements.

QA by ERIC HESS 02/01/2006

Miscellaneous Data

GURLEPH, ONNE K123
Control #: S0C60214
Part #: 74274441
.135 X 48 X 96

Date: 03/17/06

SOLD TO: INDIAN LASSER

TO 110880

S/O 90-374786 - 02

[Signature] 3/17/06

The Chemical Analysis and Mechanical Test
data was received via EDI from the above
mentioned vendor.

INTEGRIS METALS, LTD.